5145

SPLIT 52

DART AEROSPACE LTD.	Work Order:	24433
Description: Saddle Fitting, Fwd (Outboard/Inboard)	Part Number:	D2571/D2572
Drawing: D2571 Rev. D/D2572 Rev. D	Qty:	8
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DÇ	Issue Traveller	JA.		
		Dwg not required	KT	05,10,12	8
2	MV	Make from D6101-007 billet for D2571			
		Ensure that grain is along 7.75" length	1	1	
		Batch No: 12 24 a 9 3	5G	osliala3	8
3	MV	Make from D6101-005 billet for D2572		5.10193	-
		Ensure that grain is along 5.00" length			
		Batch No: B21817 - A	1 5.G	05/12/23	8
4/	MV/	Fixturing W/O Nø.	/	1	/ /
1		Pixturing Inspection last completed / by		NIA/	/
5	MV	Program Batch No. 24433			
		Double check by:	T.]	05.11.28	8
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached	. /	D Z - 1 - MC V	
		Dimension Sheets	ms/	celoile3	3
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached	/	20101103	
		Dimension Sheets	148/1	ceroiles	7
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached	18/		
		Dimension Sheets	77	calcile3	6
9	MV	Machine keyway as per dwg D2571 & D2572	1		
			175/	06/01/03	8
10	MV	Deburr and remove all machining marks	Mis	10	
2.3			TIL	Olderles	3
11	MV	Tumble for 20 minutes to semone shar edges Hoy a 21	M8/		
40	201		SI	celorlos	Ü
12	QC1	Inspect all dimensions to dimension sheets	· MG/		
10	007		SL	06/01/03	害力
13	QC7	Second inspection		2 V 12	
			CO	06/0//01	5 7
14	FP	Acid etch and alodine as per QSI 005 4.1	5	11	7/
15			ITT	06/01/11	1/5
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3			1/
10	0.00	No. of the second secon	1111	06 01 16	15
16	QC3	Inspect Powder Coat	1	11	1
47	OT	TANK Melican American	1- 0	6/1/17	7/5
17	ST	Identify and Stock.	1	///	1
10	100	Luc 312	100	0/1/17	1/
18	AC	Cont / Post	A	11	/ 3
10	DC	Cost / Part	Suz-	d-01-18	
19	DC	Close W/O		1 1	
		Inspection Level 21	45	36/01/18	

Rev	Date	Change	Revised By	Approved	
G	01.04.27	Added D6101-007 & step 8	FC	Approved	
Н	02.02.01	Added Inspection level 5 and Inspection Level 21	SM		
1		Re-format; Change to Dwg Rev. D & incorporated D2572	KJ RF	-0/(



1.7 5,07.07

